



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3560-043
Job Sheet 175948



Part No: D3560-043

Job Qty: 2 ea

Part Name: Arm Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 07.05.24 EC IPP Rev B ECN 987 07.10.09 EC IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		5/19/18	0.00	0.00	Start Up Large Fab-4		CPC
140	Large Fab	2 pcs		5/19/18	0.00	1.68	Large Fab 2		CPC
150	QC	2 pcs		5/19/18	0.00	0.00	QC5		CPC
160	QC	2 pcs		5/19/18	0.00	0.00	QC9		CPC
170	HandFinish	2 pcs		5/19/18	0.00	0.26	HandFinish1		BEB, 8-05-09
180	QC	2 pcs		5/19/18	0.00	0.00	QC7-2		CPC
190	Small Fab	2 pcs		5/21/18	0.00	0.07	Small Fab-4		D.M.L.
200	QC	2 pcs		5/21/18	0.00	0.00	QC5		CPC
210	Packaging	2 pcs		5/21/18	0.00	0.00	Packaging3-1		D.M.L.
220	QC21-SA	2 Ea		5/21/18	0.00	0.00	QC21		21 MAY 10 2018

Part Op 140 - 1-Weld assembly as per dwg D3560 10- from half way point weld the rest of the first side (ease off pedal near end)

Descriptions: 11- same for remaining side (ease off pedal near end)

190 - 1-Press bushing in D3560 arm per dwg D3562

210 - *** STOCK IN STEP CELL***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3560-3	Arm	2 Ea (1 ea)	90-Start up Operation	5006521 (1x)
D3592-1	Plate	2 Ea (1 ea)	90-Start up Operation	5063834
D2808	Spacer	2 Ea (1 ea)	190-Small Fab	B755607

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3560-3	2	1	0
	D3592-1	2	20	0
190-Small Fab	D2808	2	18	0

Part Specifications

Specifications could not be found.

003106

5069585

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

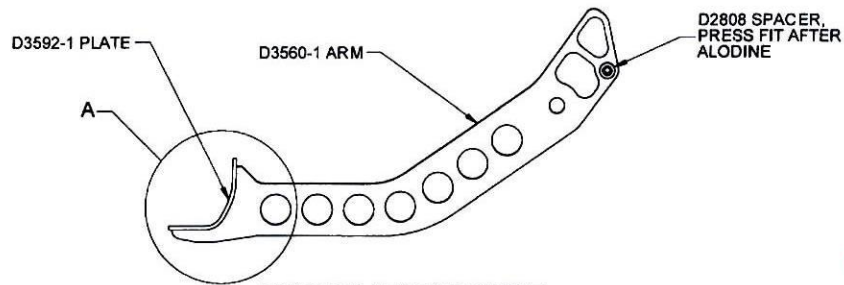
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐								
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																								
Description Work Order Deviation		Disposition		Completed By																								
				Lead hand / Supervisor Approval Verification																								
				QC / QA Coordinator Approval																								
Root Cause <table style="width:100%; border: none;"> <tr><td>Environment</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td></tr> </table> DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S069585 Part: D3560 - 043 Job No: 175948 Serial No/Batch: S069585 Revision: _____ Inspector: _____ Date: 05/09/16					Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐
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<table style="width:100%; border: none;"> <tr> <td style="width: 40%;"> Power Loss/Surge ☐ io/Program ☐ ain ☐ eld ☐ rong Stock Pulled ☐ at of Sequence ☐ ff-set ☐ lislabeled ☐ it/Function ☐ Misaligned/off center ☐ </td> <td style="width: 60%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>					Power Loss/Surge ☐ io/Program ☐ ain ☐ eld ☐ rong Stock Pulled ☐ at of Sequence ☐ ff-set ☐ lislabeled ☐ it/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																						
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Past Due ☐ OTHER : _____																												

RELEASED
07.12.16

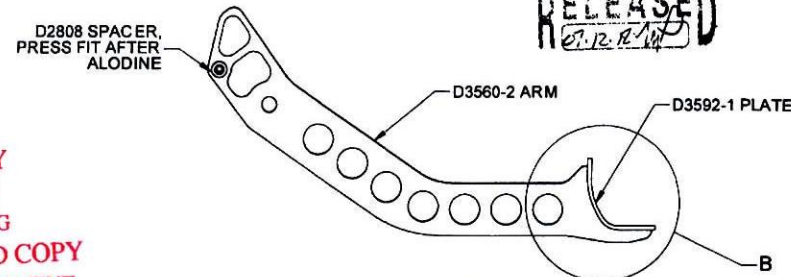
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER**

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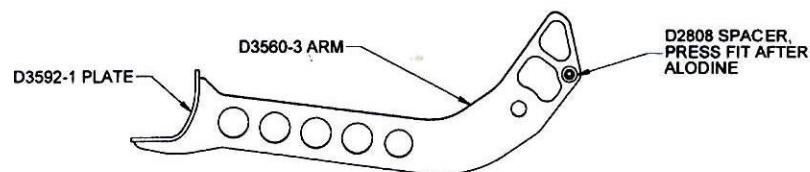
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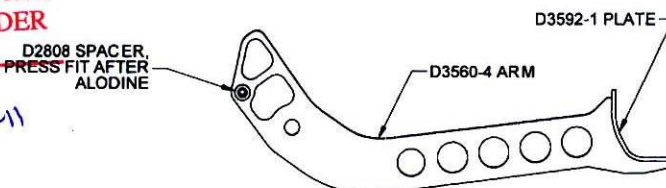
D3560-041 ARM WELDMENT



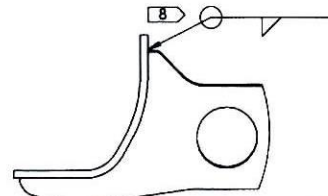
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1:2**

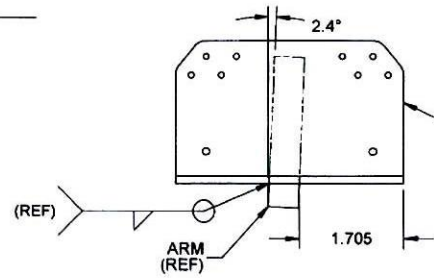
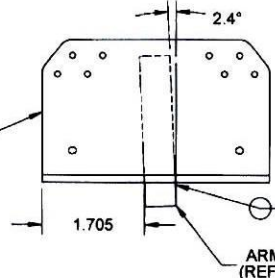
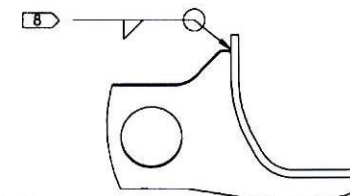


PLATE
(REF)



ARM
(REF)



**DETAIL B
SCALE 1:2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3560 ARM WELDMENT REV. D SHEET 1 OF 5 SCALE 1:4 COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

- NOTES:**
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.23 lbs (TYP)
8) WELDING: PER DART QSI 004